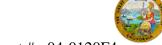
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-019877 Address: 333 Burma Road **Date Inspected:** 14-Dec-2009

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: See Below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 10BW / Bay 14

This Caltrans QA inspector observed Flux Cored Arc Welding (FCAW) in progress. Welder is identified as #045175, welding weld joint #SSD13A-PP98-128 using WPS-B-T-231-TC-U4b-F. ZPMC QC inspectors are identified as Mr. Xu Tao and CWI, Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 11DE / Bay 14

This Caltrans QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. ZPMC NDT Inspection Notification Document number is identified as #4853. This QA Inspector generated an UT report for this date. The following welds were tested on the inside longitudinal beam joining bottom plate of Segment 11DE. The welds are identified as SEG-072A-005 and SEG072A-020. See Caltrans Ultrasonic Test Report (TL6027), dated 12-14-09 for additional information.

OBG Segment Name: Bottom Plate / Bay 19

This Caltrans QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. ZPMC NDT Inspection Notification Document number is identified as #4858. This QA Inspector generated an UT report for this date. The following plate splice welds were tested on bottom plate BP025-013-001, BP-025-013-002, BP025-013-003, BP026-013-001, BP-026-013-002 and

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

BP026-013-003. See Caltrans Ultrasonic Test Report, date 12-14-09 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

"As noted within the contents of this report."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer